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AUG 21 2018

005375

D350-607-141
Job Sheet 182235



Part No: D350-607-141

Job Qty: 1 ea

Part Name: AS350/AS355 Automatic Lid Opener (Long Basket, non split lid)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/21/18

Job Tracking No:

Due Date: 9/14/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP RevA: New issue DD verified by:EC IPP RevB: as per dwg revC DD 10.01.18 verified by:EC
IPP RevC as per ecn10-545 DD 10.04.19 verified by:EC

Ship Via:

Chgo

DAS
21
9-89

See attachment

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/14/18	9/14/18	0.00	0.00	Start Up Stores/Pkg-2		DAS SEP 11 2018
110	Packaging	1 pcs	9/14/18	9/14/18	0.00	0.00	Packaging1-3		69
120	QC	1 pcs	9/14/18	9/14/18	0.00	0.00	QC4		9-89 OCT 09 2018
130	Packaging	1 pcs	9/14/18	9/14/18	0.00	0.00	Packaging3-1		69 OCT 09 2018
135	DC	1 pcs	9/14/18	9/14/18	0.00	0.00	DC		9-89 OCT 09 2018
140	QC21-FG	1 Ea	9/14/18	9/14/18	0.00	0.00	QC21		DAS 21 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN310-4	Nut	4 Ea (4 ea)	90-Start up Operation	50600621
AN3C11A	Bolt	4 Ea (4 ea)	90-Start up Operation	FM138621-71
AN3C16A	Bolt	4 Ea (4 ea)	90-Start up Operation	FM13664880
D3953-1	Gas Spring Bracket	2 Ea (2 ea)	90-Start up Operation	F105464
D3953-11	Gas Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5072728
D3953-13	Gas Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5094826
D3953-3	Gas Spring Stud, Lid	2 Ea (2 ea)	90-Start up Operation	5064730
D3953-5	Gas Spring Stud, Base	2 Ea (2 ea)	90-Start up Operation	F103984
D3953-7	Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5097232
D3953-9	Gas Spring Washer	4 Ea (4 ea)	90-Start up Operation	511399
D3969-1	Spring (Basket Lid)	2 Ea (2 ea)	90-Start up Operation	5078976
MS21043-3	Nut	8 Ea (8 ea)	90-Start up Operation	5083543
MS24665-2-12	Cotter Pin	4 Ea (4 ea)	90-Start up Operation	F125044
NAS1149C0332R	Washer	8 Ea (8 ea)	90-Start up Operation	5104354
NAS1149C0432R	Washer	4 Ea (4 ea)	90-Start up Operation	5050052

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN310-4	4	134	0
	AN3C11A	4	36	0
	AN3C16A	4	32	0
	D3953-1	2	3	0
	D3953-11	2	47	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description in Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
En _____ Equip/ _____ Handling _____ Material _____ Internal Trans _____ Tribal Knowledge _____ LOA _____ Substation _____ Past Expiry Date _____ Misidentified _____		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence			
Container No: S116548 Part: D350-607-141 Job No: 182235 Serial No/Batch: S116548 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH94-14 Issue 7aef FA00STG SR002131		OTHER : _____			

D3953-13	2	6	0
D3953-3	2	18	0
D3953-5	2	8	0
D3953-7	2	34	0
D3953-9	4	19	0
D3969-1	2	48	0
MS21043-3	8	1,150	0
MS24665-2-12	4	134	0
NAS1149C0332R	8	4,714	0
NAS1149C0432R	4	1,127	0

Part Specifications

Specifications could not be found.

Plex 8/21/18 8:42 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

1.0 INTRODUCTION

1.1 D350-607-041/-043/-045/-047 *Heli-Utility-Basket™*

The Dart D350-607-041/-043/-045/-047 *Heli-Utility-Basket™* (Basket) mounts to the landing gear on the AS 350/355 aircraft. The D350-607-041/-043/-045/-047 kit can be installed on either the LH side or the RH side of the aircraft, and can be installed on either low or high gear. It is also possible to install baskets on the LH and RH sides of the aircraft simultaneously.

The D350-607-041/-043 Baskets are oval in shape, 96.00" in length and are capable of carrying a distributed cargo load of 200 lbs (91 kgs) (see Figure 1).

The D350-607-043 Basket features a split lid for increased clearance between the open lid and the aircraft fuselage allowing for compatibility with some side cargo compartment extenders (see Figure 1).

The D350-607-045/-047 Baskets are oval in shape, 56.75" in length and are capable of carrying a distributed cargo load of 200 lb (91 kg). Similar to the D350-607-043 Basket the D350-607-047 Basket features a split lid (see Figure 1).

The D350-607-041A/-043A/-045A/-047A Baskets are identical to D350-607-041/-043/-045/-047 except that they have been upgraded at the factory to include the D350-607-141/-143/-145 Gas Spring Kits as applicable.

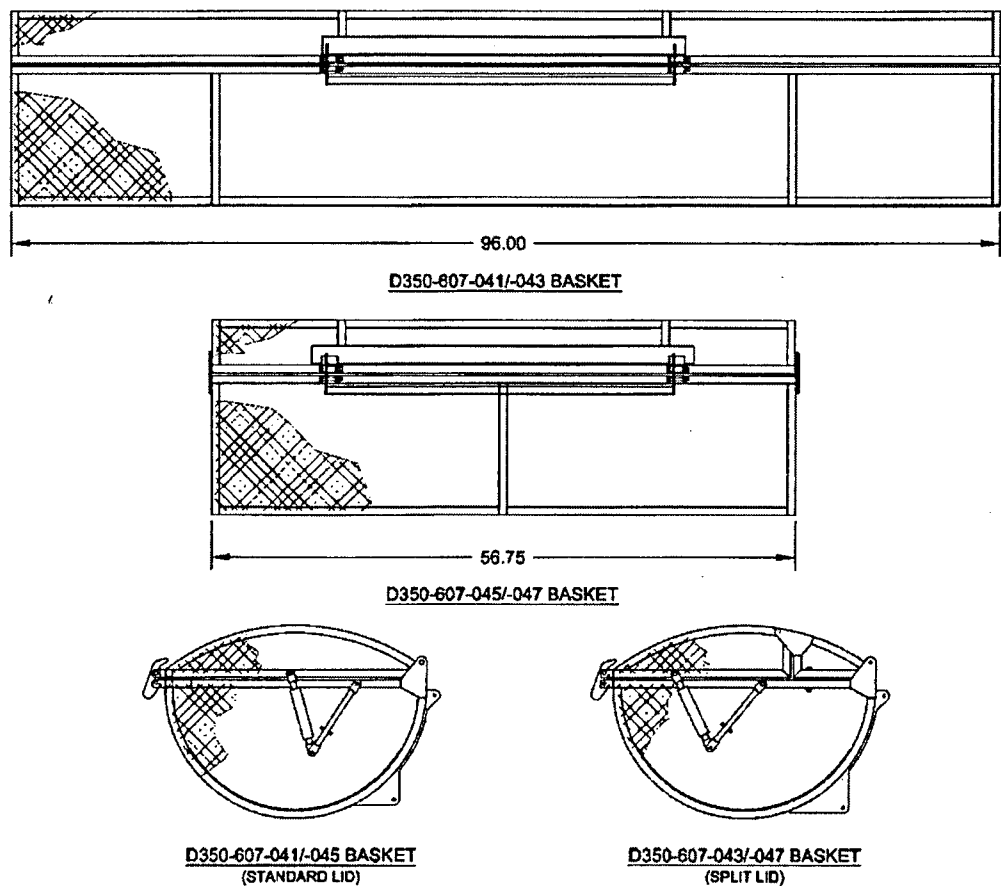


Figure 1: D350-607-041/-043/-045/-047 Baskets

6.3 D350-607-141/-143/-145 AUTOMATIC LID OPENER INSTL

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-607-141	AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET)
	X		D350-607-143	AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)
		X	D350-607-145	AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET)
2		1	D3953-1	GAS SPRING BRACKET
2	1	1	D3953-3	GAS SPRING STUD (LID)
2	1	1	D3953-5	GAS SPRING STUD (BASE)
2	1	1	D3953-7	GAS SPRING SPACER
4	2	2	D3953-9	GAS SPRING WASHER
2	1	1	D3953-11	GAS SPRING SPACER
2		1	D3953-13	GAS SPRING SPACER
	1		D3953-15	GAS SPRING BRACKET
	1		D3953-17	GAS SPRING SPACER
2	1	1	D3969-1	GAS SPRING
4	2	2	AN3C11A	BOLT
	2		AN3C15A	BOLT
4		2	AN3C16A	BOLT
4	2	2	AN310-4	CASTELLATED NUT
8	4	4	MS21043-3	NUT
4	2	2	MS24665-212	COTTER PIN
8	4	4	NAS1149C0332R	WASHER (OR AN960C10L)
4	2	2	NAS1149C0432R	WASHER (OR AN960C416L)

Change Record

PAGE 1 OF 1

Part Number: D350-607-141

Description: AUTOMATIC LID OPENER (FOR -041 BASKET)[illegible]